

split 2nd

Work Order ID 53212-2

October 26, 2009 2:18:24 PM

Page 1

PRELIMINARY ISSUE

Item ID: D4013-041  
Revision ID: A-PRELIM  
Item Name: Wearplate Assembly

Start Date: 10/26/09 Start Qty: 4.00  
Required Date: 10/28/09 Req'd Qty: 4.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4013    | A-PRELIM     |

100

0.00



Waterjet  
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D4013-1  
Dwg Rev: PRE  
Prog Rev: LM

2-Deburr if necessary

0.00

9-10-27

110

0.00



QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Scrap split  
u

6

9-10-27

**Work Order ID 53212**

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Accept

Setup Start

Stop

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Run Start

Stop

| Sequence ID/<br>Work Center ID                                                                                      | Operation<br>Description                                  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120<br><br>QC<br>Quality Control   | QC8- Inspect parts - second check<br><br>Memo             | 0.00<br><br>0.00     | 27 Sordus/27   | Mon, 10.27   |              | (26)          | f             |                  |                |
| 130<br><br>Brake NC<br>Brake NC    | Bend as per dwg<br><br>Memo                               | 0.00<br><br>0.00     |                |              |              | (6)           |               |                  |                |
| 140<br><br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br><br>0.00     | 27 Sordus/28   | Mon, 10.28   |              | (26)          | f             |                  |                |

# Work Order ID 53212

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Item ID: D4013-041  
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Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 10/26/09 Start Qty: 4.00  
Required Date: 10/28/09 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                       | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------------------------------------------------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 150<br>                        |                                                                                                                | 0.00                 |                |              |              |               |               |                  |                |
| Large Fab                      | Memo                                                                                                           | 0.00                 |                |              |              |               |               |                  |                |
| Large Fab                      | Weld cup, stud and apply hardfacing as per dwg<br>A/R S.S. ROD BATCH: _____<br>A/R HARDCOAT 2059B BATCH: _____ |                      |                |              |              |               |               |                  |                |
| 160<br>                        | QC5- Inspect part completeness to step on W/O                                                                  | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo                                                                                                           | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |                                                                                                                |                      |                |              |              |               |               |                  |                |
| 170<br>                        | QC9- Inspect visual per QSI004- Fusion Welds                                                                   | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo                                                                                                           | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |                                                                                                                |                      |                |              |              |               |               |                  |                |

SCOP 3 12st  
dwg change  
per Marc B.  
07-11-03

# Picklist Print

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## Work Order ID 53212

October 26, 2009 2:18:25 PM

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID      | Operation<br>Description                             | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-------------------------------------|------------------------------------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 180<br>Powdercoat<br>Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3<br><br>Memo | 0.00<br><br>0.00     |                |              |              |               |               |                  |                |
| 190<br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo                 | 0.00<br><br>0.00     |                |              |              |               |               |                  |                |
| 200<br>Packaging<br>Packaging       | Identify as per dwg & Stock Location:<br><br>Memo    | 0.00<br><br>0.00     |                |              |              |               |               |                  |                |



Setup Start

Stop

Cust Item ID:  
Customer:

Run Start

Stop

RD0324A00V

POSITIVE RECALL

EFFECTIVE 8/11/12 AUTH

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W 9.11.09

|                                                      |  |                               |
|------------------------------------------------------|--|-------------------------------|
| <b>DART AEROSPACE LTD</b>                            |  | <b>Work Order:</b> 53212      |
| <b>Description:</b> WEAR PLATE ASS'y                 |  | <b>Part Number:</b> D4013-041 |
| <b>Inspection Dwg:</b> D4013-1 <b>Rev:</b> PRE. Lien |  | Page 1 of 1                   |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .257            | + .006 - .001 | .263             | X      |        |                      |          |
| Ø .875            | + .010 - .001 | .877             | X      |        |                      |          |
| Ø 1.88            | + .012 - .001 | 1.880            | X      |        |                      |          |
| 1.500             | ± .010        | 1.502            | X      |        |                      |          |
| 2.125             | ± .010        | 2.124            | X      |        |                      |          |
| 2.75              | ± .030        | 2.74             | X      |        |                      |          |
| .625              | ± .010        | .625             | X      |        |                      |          |
| 2.125             | ± .010        | 2.123            | X      |        |                      |          |
| 3.625             | ± .010        | 3.626            | X      |        |                      |          |
| 7.063             | ± .010        | 7.065            | X      |        |                      |          |
| 7.458             | ± .010        | 7.459            | X      |        |                      |          |
| 11.271            | ± .010        | 11.274           | X      |        |                      |          |
| 14.896            | ± .010        | 14.896           | X      |        |                      |          |
| 18.646            | ± .010        | 18.646           | X      |        |                      |          |
| 22.396            | ± .010        | 22.396           | X      |        |                      |          |
| 24.106            | ± .010        | 24.106           | X      |        |                      |          |
| 25.231            | ± .010        | 25.231           | X      |        |                      |          |
| 1.50              | ± .030        | 1.502            |        |        |                      |          |
| .063              | ± .010        | .059             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                      |                                |
|------------------------|----------------------|--------------------------------|
| <b>Measured by:</b> RB | <b>Audited by:</b> S | <b>Prototype Approval:</b> N/A |
| <b>Date:</b> 9-10-27   | <b>Date:</b> 9/10/22 | <b>Date:</b> N/A               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

# Receiving Report

Date: 9/9/02

Batch No: M112567

Supplier: MAGNA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☐ No ☒ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 09109102 N/A ☒

## Discrepancies

| Part Number      | Description             | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|------------------|-------------------------|------------------|-------------------|-------------------|----------------|----------|
| <del>M6061</del> | <del>TGB-200x0400</del> | <del>40</del>    | <del>0</del>      | <del>0</del>      | <del>40</del>  |          |
| M6061            | 30181x0400              | 40               | 0                 | 0                 | 40             |          |
| M6061            | TGB1-200x0400           | 40               | 0                 | 0                 | 40             |          |

M6061 TGB-200x0400

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

09/09/02

RCR 10312

CY

Location

M 3045126A

64 0 0 69



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09  
PO Print Date 9/01/09

Page Number 4 of 4

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

16 ✓ M304S16GA

304/316 Sheet .063

9/04/09

Yes

✓ 96  
92.00

sf

Yours ppd

\$5.0000

\$460.00

Special Inst: AS ABOVE

17 ✓ M304S20GA

304/316 .040 Sheet

9/04/09

Yes

✓ 192.00

sf

\$3.9062

\$749.99

Special Inst: AS ABOVE

PO Total:

\$5,356.49

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

W CZ

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 9/01/09

This MTR contains 1 page (Page: 1)

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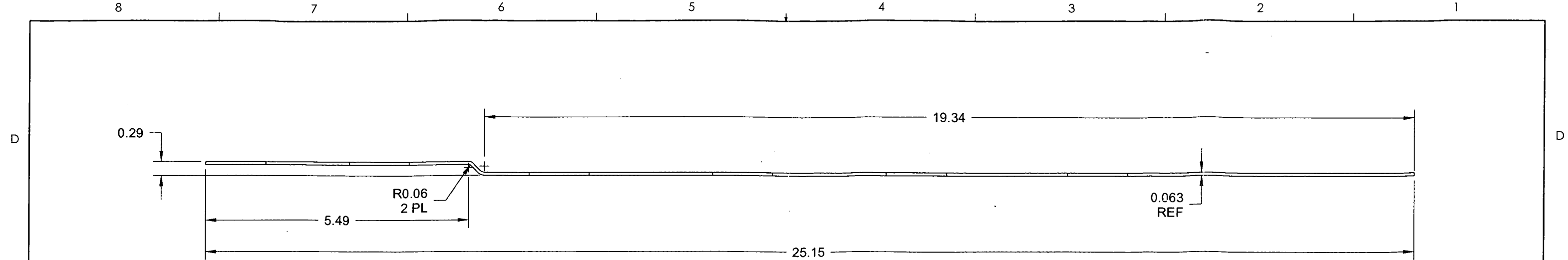


TICL2121

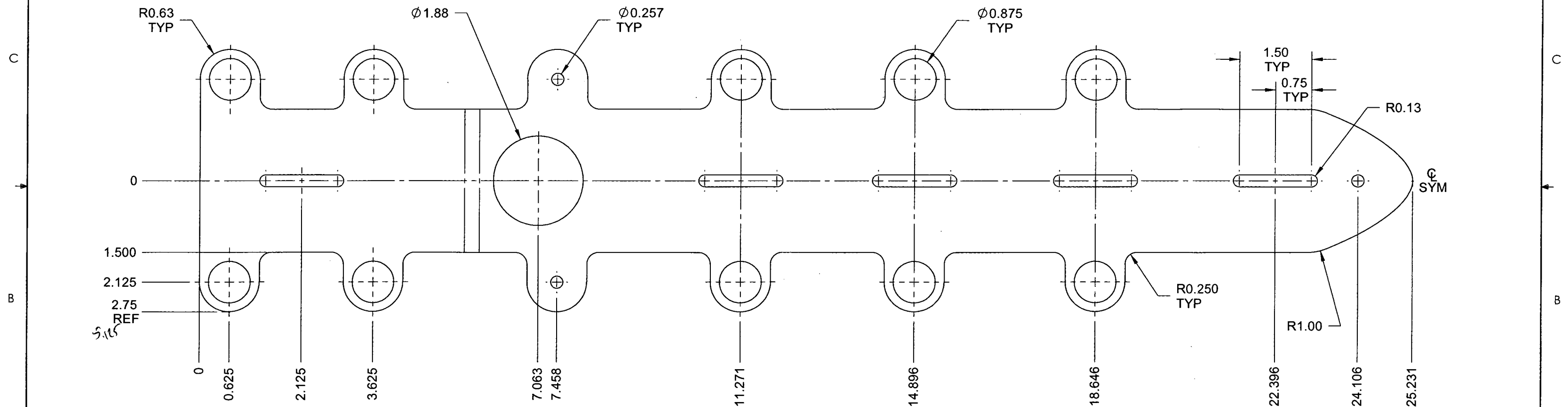
Page: 7 of 19

2006327- A28002330





**D4013-1 WEARPLATE**  
(MAKE FROM D4013-1F)



**D4013-1F WEARPLATE FLAT PATTERN**

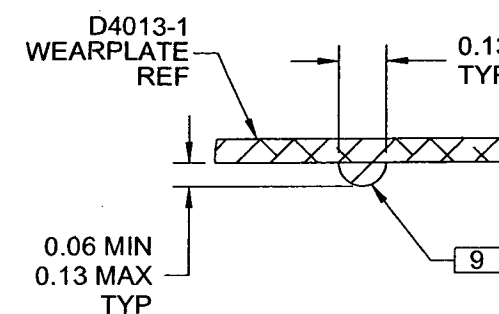
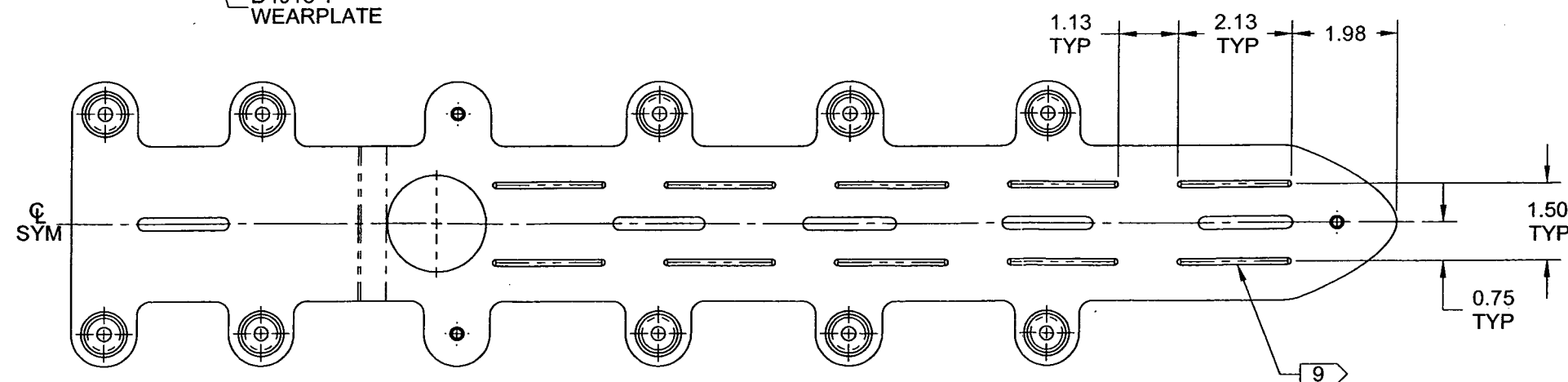
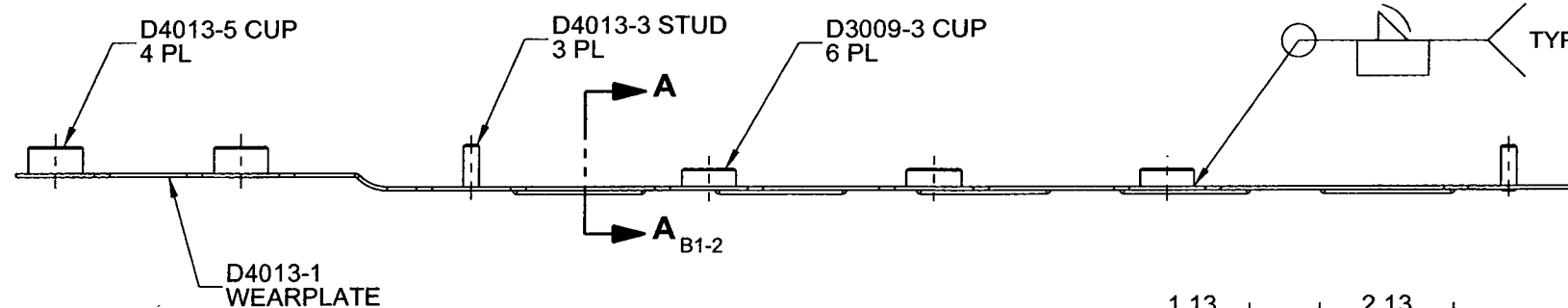
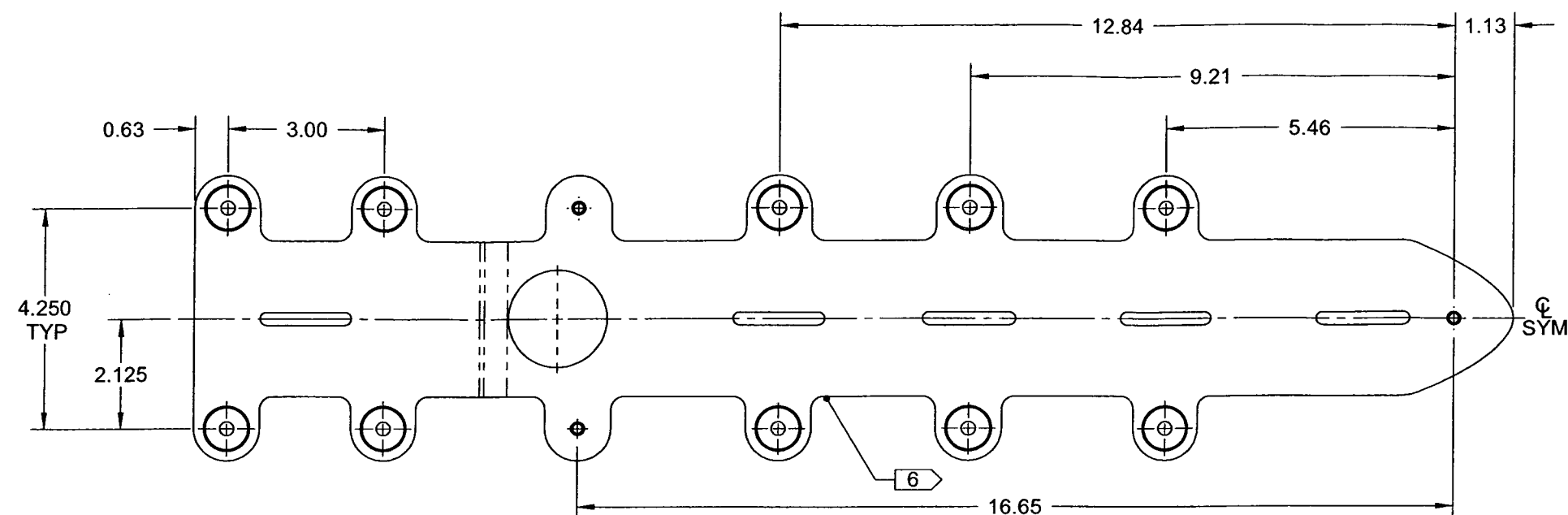
4

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.42 lbs

**PRELIMINARY ISSUE**  
ASS RMB 09.10.26

|            |          |                                                                                                                                                                                                                                                                                |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | ASS GMB  | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                      |              |
| DRAWN      | ASS RMB  | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                    |              |
| CHECKED    | ASS      | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. A       |
| MFG. APPR. | M        | D4013                                                                                                                                                                                                                                                                          | SHEET 3 OF 4 |
| APPROVED   | ASS RMB  | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   |          | WEARPLATE ASSEMBLY                                                                                                                                                                                                                                                             | NTS          |
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**SECTION A-A** B6-2  
SCALE 6X

**D4013-041 WEARPLATE ASSEMBLY**

**NOTES:**

- 1) MATERIAL: SEE SHEETS 3 AND 4
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.72 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 10 PL

|            |          |                                                                                                                                                                                                                                                                                          |              |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                              |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. A       |
| MFG. APPR. |          | <b>D4013</b>                                                                                                                                                                                                                                                                             | SHEET 2 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |          | <b>WEARPLATE ASSEMBLY</b>                                                                                                                                                                                                                                                                | NTS          |
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**PRELIMINARY ISSUE**

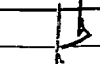
04.10.26  
POR COW #09-6950

| ITEM | QTY<br>-041 | P/N       | DESCRIPTION        |
|------|-------------|-----------|--------------------|
| 1    | X           | D4031-041 | WEARPLATE ASSEMBLY |
| 11   | 6           | D3009-3   | CUP                |
| 12   | 1           | D4013-1   | WEARPLATE          |
| 13   | 3           | D4013-3   | STUD               |
| 14   | 4           | D4013-5   | CUP                |
| 21   | A/R         | 2059B     | HARDCOAT           |

1 D4013-041 WEARPLATE ASSEMBLY

PRELIMINARY ISSUE

09.10.26  
PER GCN #04-6958

|            |                                                                                                                                                                                                                                                                                           |                          |          |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|----------|
| A          | NEW ISSUE                                                                                                                                                                                                                                                                                 | MB                       | 09.10.22 |
| REV.       | DESCRIPTION                                                                                                                                                                                                                                                                               | BY                       | DATE     |
| DESIGN     | <div> <div>  </div> <div> <b>DART AEROSPACE LTD</b><br/> HAWKESBURY, ONTARIO, CANADA </div> </div>                                                                                                   | REV. A                   |          |
| DRAWN      |                                                                                                                                                                                                                                                                                           | SHEET 1 OF 4             |          |
| CHECKED    |                                                                                                                                                                                                                                                                                           | DRAWING NO. D4013        |          |
| MFG. APPR. |                                                                                                                                                                                                                                                                                           | TITLE WEARPLATE ASSEMBLY |          |
| APPROVED   |                                                                                                                                                                                                                                                                                           | SCALE NTS                |          |
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| DATE       | 09.10.22                                                                                                                                                                                                                                                                                  |                          |          |